

Work Order ID 72543

Thursday, July 28, 2011 2:51:33 PM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 7/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*H*Date: *11-07-28*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

SAD/De 11.08.11

105

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

*S w 08/12**(+6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Start Date: 7/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107 Large Fab	Weld per dwg A/R S.S. rod Batch <u>1114649</u>	0.00							
Large Fab	Memo 1- weld bushing as per dwg D3916 2- grind welds flush	0.00							
110 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
120 QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							

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Picklist Print

Thursday, July 28, 2011 2:51:40 PM

Page 1

Work Order ID: 72543

Parent Item: D3916-041

Parent Item Name: Rib Assembly



Start Date: 7/28/2011

Required Date: 8/4/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	137.0000	7	42			
Bushing													

Location Loc Qty Loc Code

WA 135

69202 135

WA005 2

66489 2

M304TS0.750W.049		Purchased	No			100	f	574.0114	4.166	26.31158			
304 SQ Tube .75x.75x.049W													

Location Loc Qty Loc Code

MAT018 402.798609

117690 4.372109

117775 98.4265

118472 300

MAT034 2.0639

117337 2.0639

WA 169.14894

118184 169.14894

M118472 13.1557

13.1557

13.1557

PAB 11/08/12

42

SAD 11-08-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

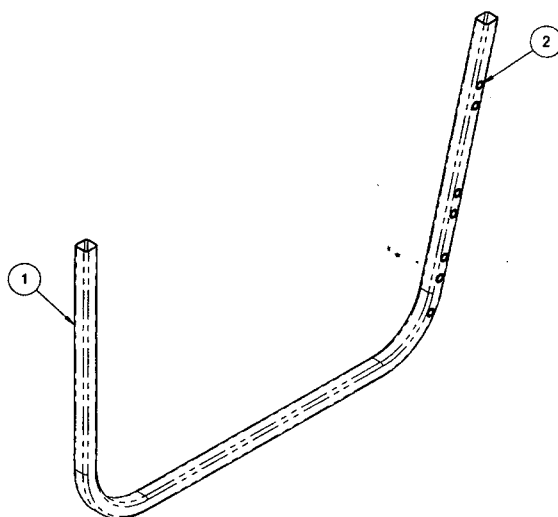
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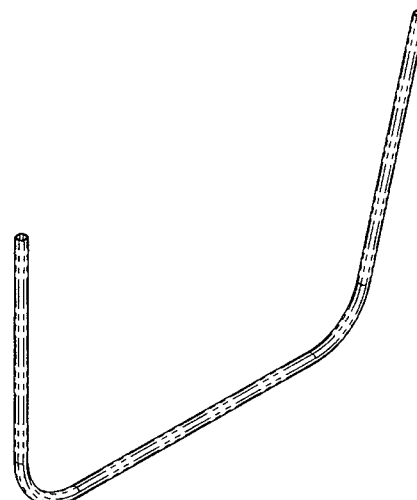
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12547

1110720

OL 10.12.21
~~UNDER REVIEW~~
10.10.11
ADDITION OF HOLE + BUSHING
ON D3916-041 RIBS.

RELEASED
2010-03-12
JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3916** REV. A
SHEET 1 OF 4
TITLE **RIB ASSY, 350 BASKET** SCALE NTS

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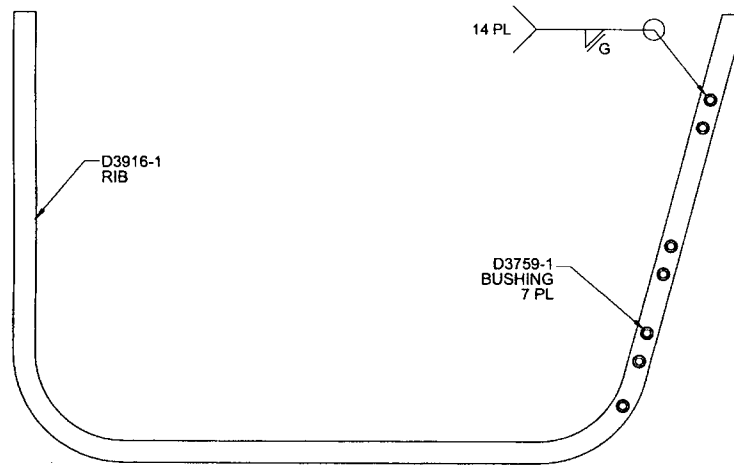
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NOTE: Date & initial all entries



D3916-041 RIB ASSY

12543

RELEASED
2010-03-12
MTP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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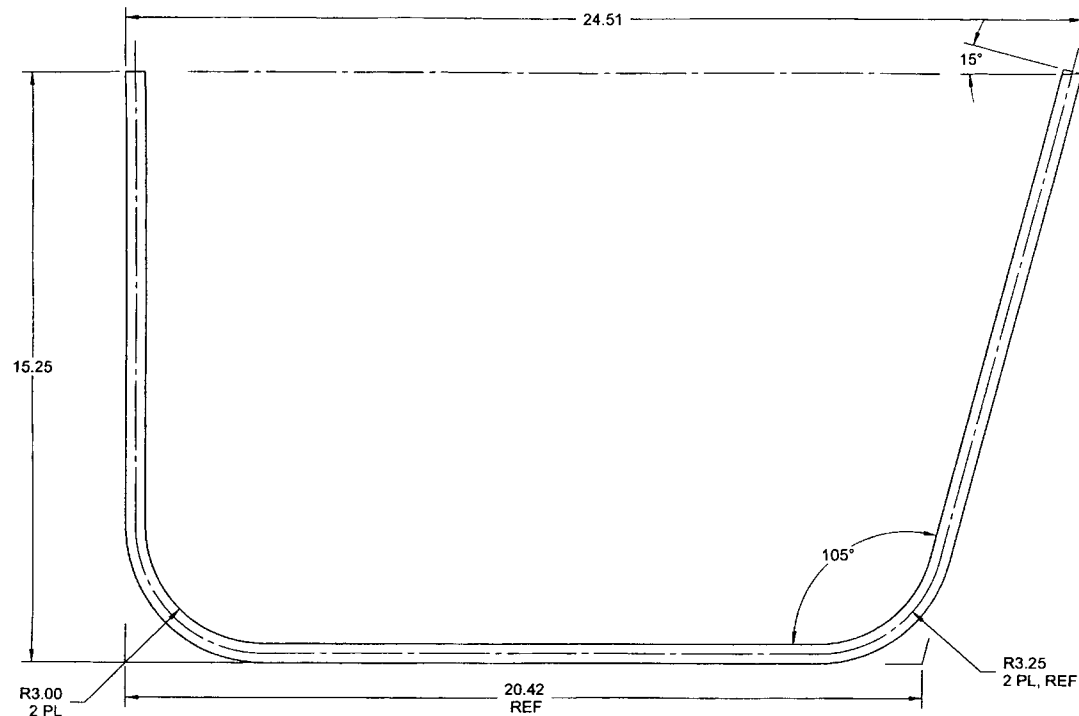
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9 > **D3916-5 LIGHT RIB**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

RELEASED
2010-03-12

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 4 OF 4
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DE APPR.		RIB ASSY, 350 BASKET	NTS
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